

Work Order ID 160554***160554***

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Monday, May 01, 2017 1:24:14 PM

Item ID: D3016-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 5/3/2017 Start Qty: 2.00 ***2*** **DAS 21 9-89** Cust Item ID:
Required Date: 5/3/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED/C **DAS 21 9-89**
Approvals: Process Plan: _____ Date: **MAY 01 2017** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3016	Rev A								
110		0.00				8	0		DAS 32 9-89
110									
Cold Saw	Memo	0.18							17-05-02
Hyd Mech	CUT LENGHT. ONE LENGHT MAKES TWO PART.								
120	Manufacture as per dwg	0.00				8	0		DAS 32 9-89
120									
Mill Conv	Memo	0.25							17-05-02
Conventional Milling Machine	- USE TOOLING DT10267 - Holes will be drilled upon assembly.								
130	QC2- Inspect parts off machine FAI/FAIB	0.00				8	0		DAS 32 9-89
130									
QC	Memo	0.04							17-05-02
Quality Control	- Holes will be drilled upon assembly.								

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							DAS 08 9-89
140									
QC	Memo	0.04				8	φ		
Quality Control	- Holes will be drilled upon assembly.								
150	Identify as per dwg & Stock Location: <u>WA01</u>	0.00							
150									
Packaging	Memo	0.04				8	12	17-5-2	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

MAY 03 2017

Picklist Print

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Work Order ID: 160554

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Parent Item: D3016-11

D3016-11

Parent Item Name: Saddle

Start Date: 5/3/2017

Required Date: 5/3/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 16.08.31 NEW PROCESS DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT1.000W.120		Purchased	No			110	f	34.0000	0.33	0.694737			DAS

M4130NT1 000W 120

4130 RD Tube 1.00 x .120wall

17-08-02

32
989

Location

Loc Qty

Loc Code

MAT033

34

m136569

10

m136846

24

2.864



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

17-05-01
NO. 160514 M5
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

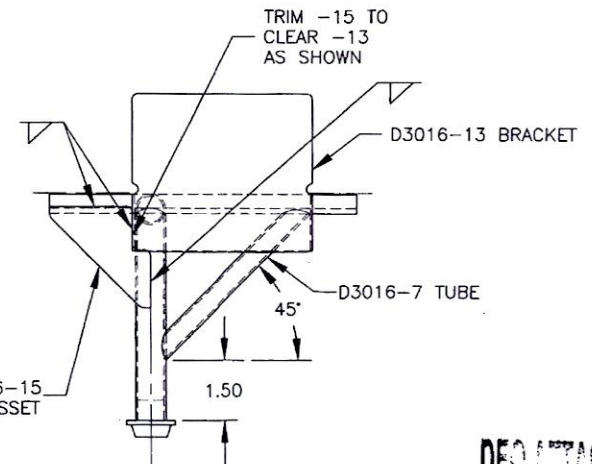
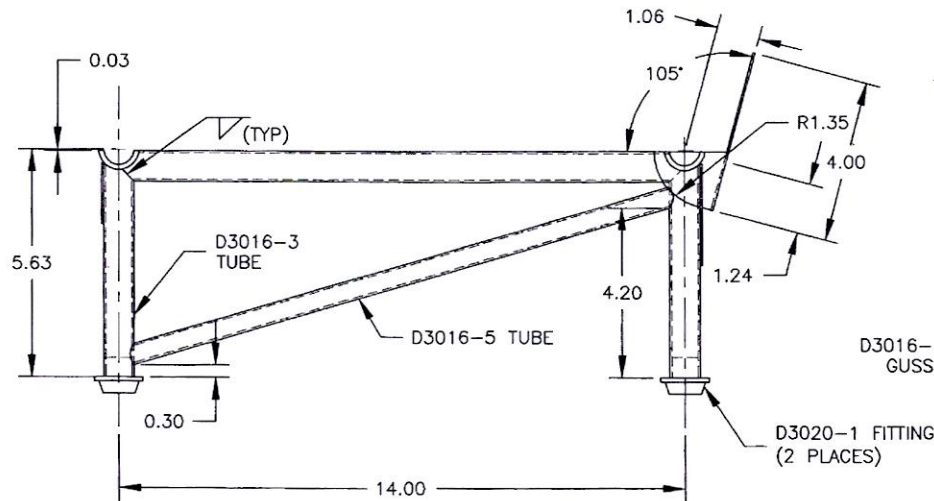
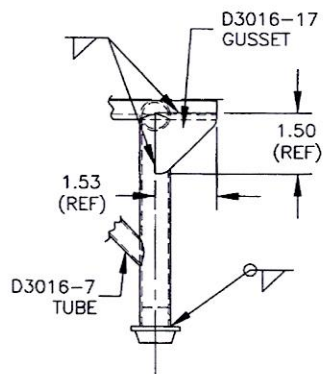
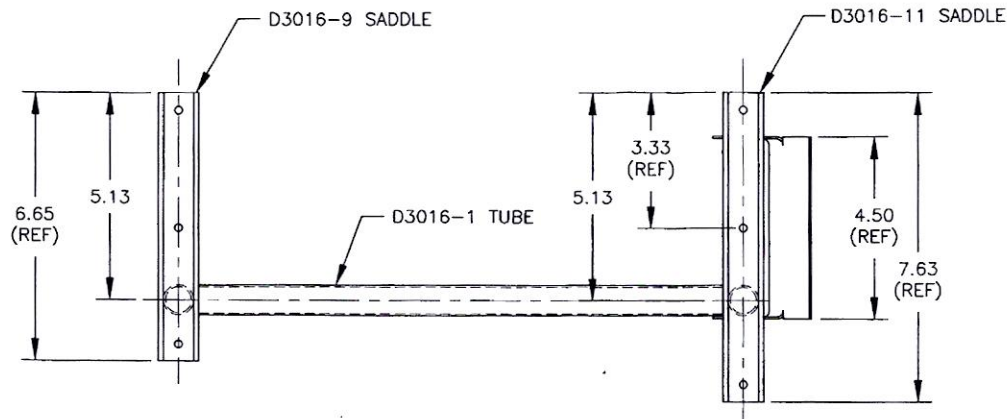
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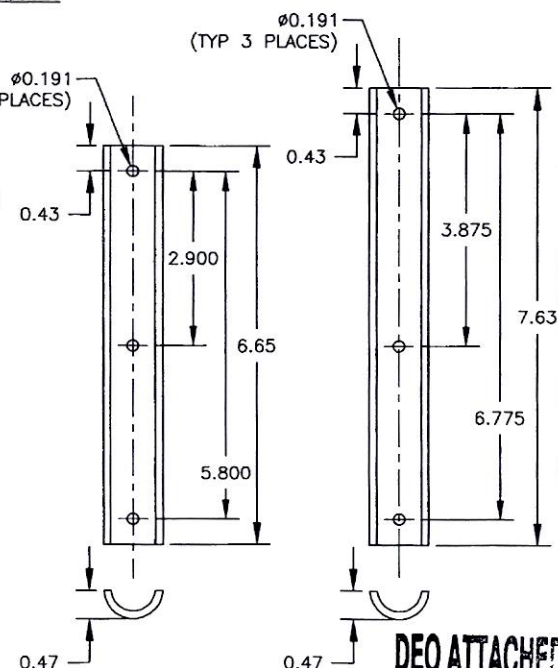
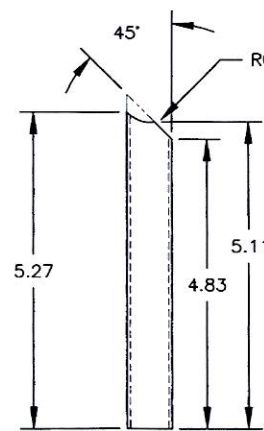
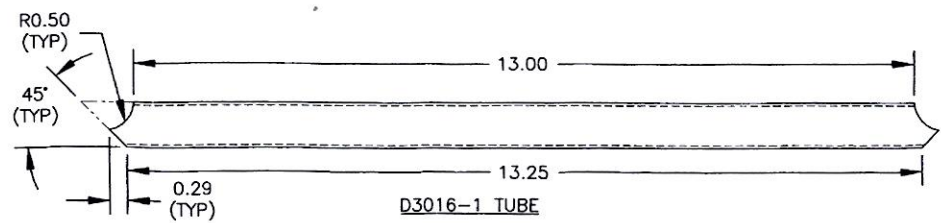
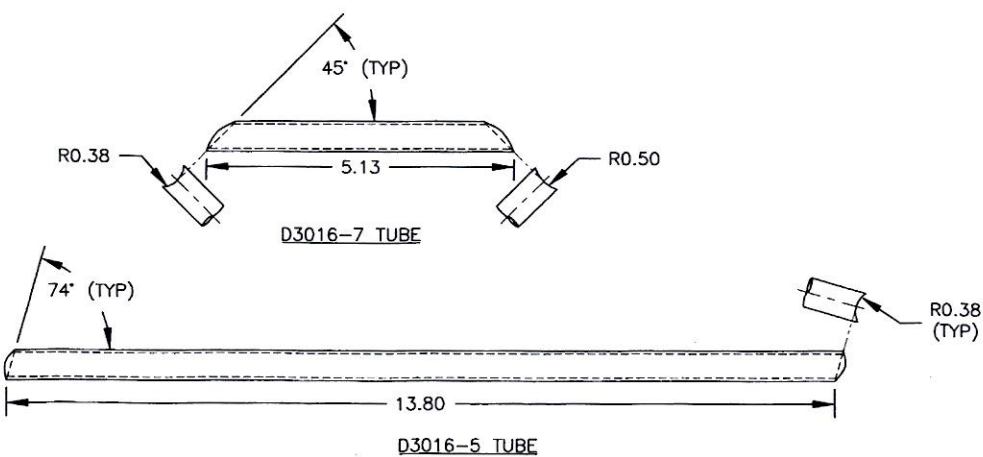
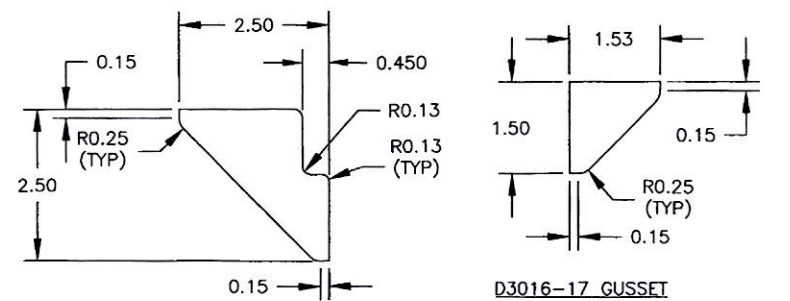
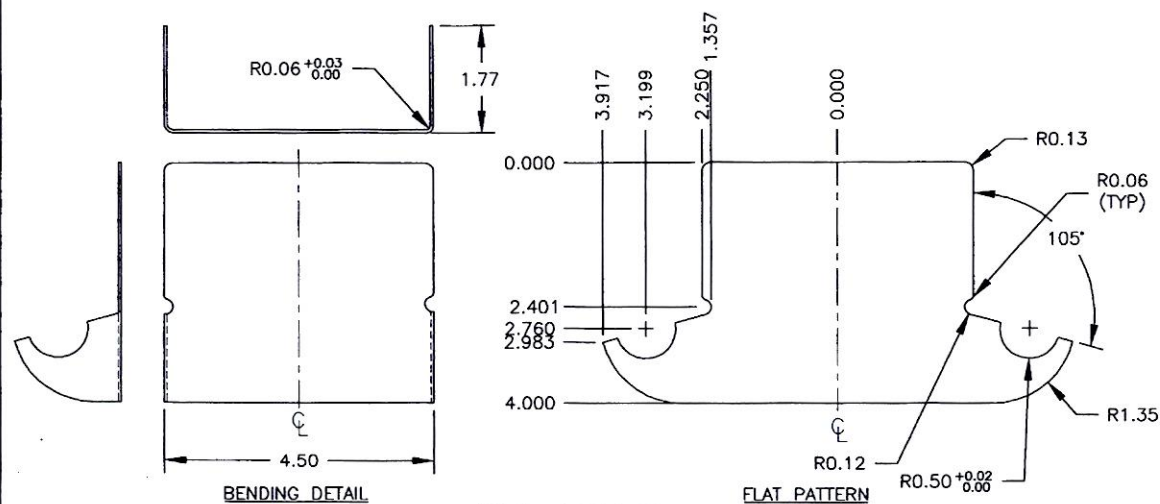
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D3016-041 SEAT FRAME ASSEMBLY



DETACHED
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01.05.30

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DATE		01.05.18	DRAWING NO.	D3016	REV. A
TITLE		SEAT FRAME ASSEMBLY		SHEET 2 OF 3	
				SCALE	
				1:3	



DEO ATTACHED
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9.05.30

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DESIGN	CP	DRAWN BY	CP	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	*	APPROVED	*	DRAWING NO.	D3016
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	REV. A	SHEET 3 OF 3
				SCALE	1:2

DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>WAP</i>	DE APPR. <i>WAP</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		

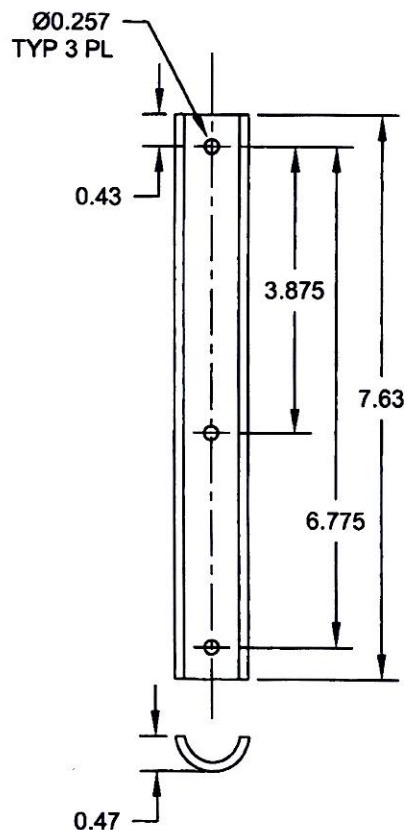
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

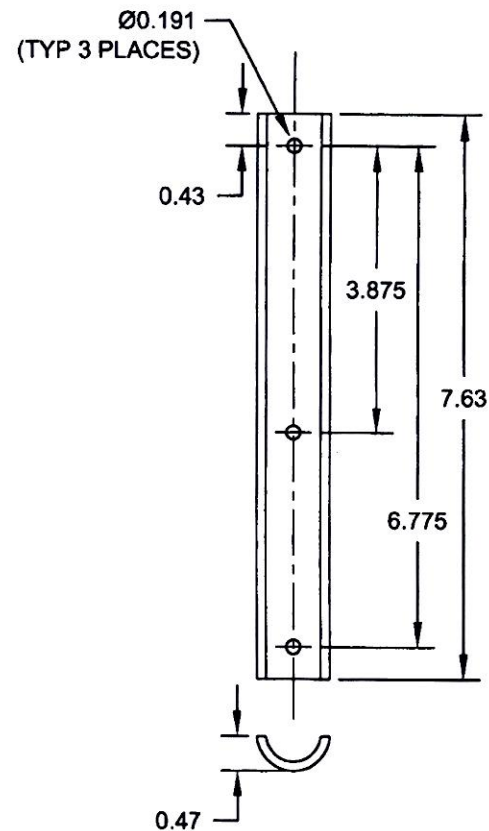
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE